

Date: Thursday, 22/02/2007 7:10:24 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 412 WEB
Job Number	: 30790		
Estimate Number	: 10466		
P.O. Number	: N/A	Part Number	: D33891
This Issue	: 22/02/2007 S.O. No. : N/A	Drawing Number	: D3389 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: C
Previous Run	: 27656	Material	: N/A
Written By	: <u>U</u>	Due Date	: 01/03/2007 Qty: 9 Um: Each
Checked & Approved By	: <u>U</u>		
Comment	: Est Rev:A 05.08.31 New issue KJ/JLM Est Rev:B 06-02-08 As per Rev C JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Ext'n - 1' Beam Web 4"
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~~Comment:~~ Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)

Ext'n - 1' Beam Web 4"

Pick:

Qty	Part Number
1	D2500-3-100

Description	Batch
Web Extrusion	B 25 751

JD 7-2-29

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut to length as per Dwg D3389

2-Drill pilot holes using DT8785 as per Dwg D3389

3-Open 1X .257" Dia Hole

4-Open Remaining holes to finish size as per Dwg D3389

5-Deburr

BE/ JD 7-2-22 (9)

Pro

3.0	QC6	DIMENSIONAL CHECK
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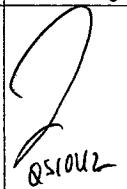

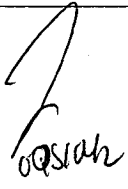

Comment: DIMENSIONAL CHECK

BE 07-02-22

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 2 Date: 07/01/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-22	2.0	one hole was missed during dry drilling, resulting in the .257 hole, getting opened up to .625. <del>the</del> Human error.	 Q51042	open the .257 → .625 Web still good, .257 was A locating hole only. the	JH 7-2-27	 07-22	 Q51042	 07-22

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 WEB

Job Number: 30790

Part Number: D33891

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Per 50 7-2-22*

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*BE 07-02-26 (9)*

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LG*

*BE 07-02-26 (9)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(9) Grakal*

Job Completion



*U 07-02-27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

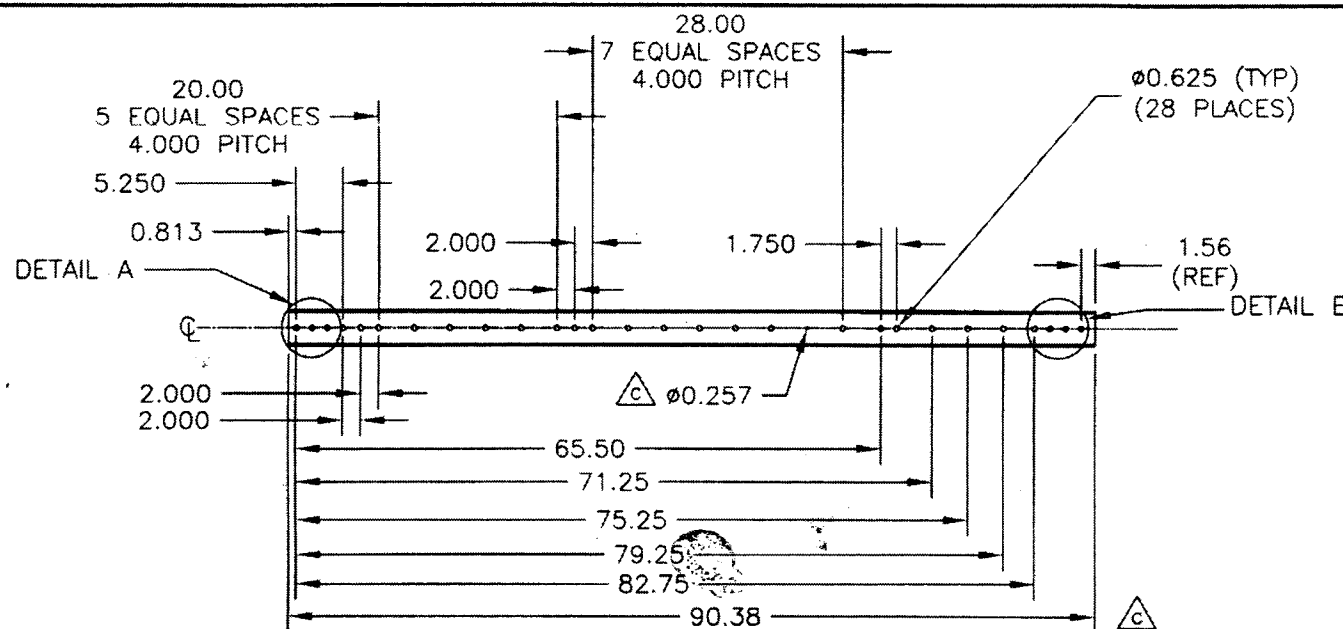
**NOTE:** Date & initial all entries



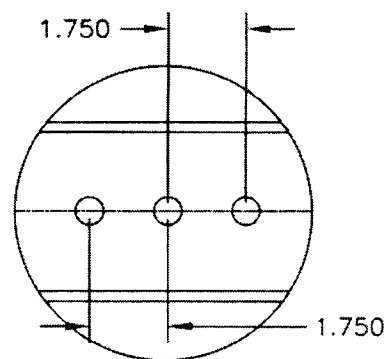
RELEASE

06.01.23

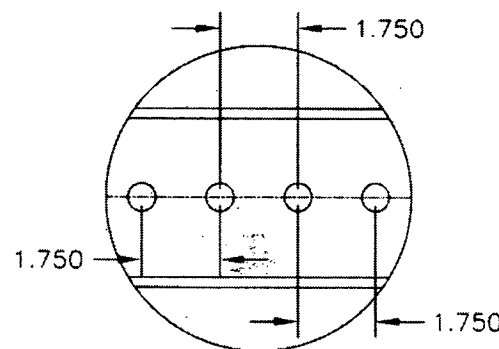
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	06.01.23	TITLE	412 WEB	REV. C
A	05.02.07	NEW ISSUE		
B	05.06.13	UPDATE DIMENSIONING		
C	06.01.23	DECREASE OVERALL LENGTH, MODIFY HOLE		



D3389-1 DRILLING DETAIL



DETAIL A  
(SCALE 1:4)



DETAIL B  
(SCALE 1:4)

D3389-1 412 WEB

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

